

Date: Thursday, 21/08/2008 5:12:11 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TAIL ROTOR PEDAL DISABLING KIT	
Job Number :	41551			
Estimate Number :	12334			
P.O. Number :		Part Number :	D3371041	
This Issue :	21/08/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3371 REV B	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	35806	Drawing Revision :	B	
	Type :	Material :		
	SMALL /MED FAB	Due Date :	05/09/2008	Qty: 2 Um: Each
Written By :				
Checked & Approved By :	<u>JUL 08.8.22</u>			
Comment :	Est Rev: A Removed from 9 Digit 06-03-10 KJ			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D33711	Pedal Lock Base
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3371-1	Pedal Lock Base	22287A

2.0	D33713	Pedal Lock Cover
-----	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3371-3	Pedal Lock Cover	22288

3.0	D33853	Hinge
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3385-3	Hinge	22387

4.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 10:00 AM

OVEN TEMPERATURE: 320°C

FINISH TIME: 10:30 AM

JH

08/11/12

(KJ)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 21/08/2008 5:12:11 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL ROTOR PEDAL DISABLING KIT

Job Number: 41551

Part Number: D3371041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F2 08/11/12 (2)

6.0

D27287

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Decal

~~39612~~

Batch
B22554 rot in
comp

SS 08/11/12 (2)

7.0

D33737

Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3373-7 KA Cam Lock

B22610

-2

CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE

8.0

AN526C832R6

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN526C832R6 Screw

M16612

SS 08/11/12 (2)

9.0

238028

3/16" Dowel Pin .5" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 238-028 3/16" dia. Dowel Pin 1/2" long

A/R N/A Locktite 262

Batch
M17278

SS 08/11/12 (2)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.

2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.

3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5

SS 08/12/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: TAIL ROTOR PEDAL DISABLING KIT

Job Number: 41551

Part Number: D3371041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty Part Number Description Batch

A/R 262 Locktite

M109985

EP 08/12/22

11.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3384-1 Cyclic Sock

37172

SS 08/11/12 (x2)

12.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CBL-460 Loop Sleeve

109062

SS 08/11/12 (x2)

13.0

CBL1240

Cable



Comment: Qty.: 1.7499 f(s)/Unit Total : 3.4999 f(s)

Pick:

Qty Part Number Description Batch

20" CBL-1240 Cable

M103927

No Qty's

EP 08/12/22

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard to cyclic sock as per Dwg D3384

Identify as D3384-045

EP 08/12/22 (2)

15.0

AN960416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer

M19356

SS 08/11/12 (x2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 41551

Part Number: D3371041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 HX-81

1/4"-20 SHCS 3/8" long

M16971

JS 08/11/12 (X2)

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371.

Identify as D3371-041 & attach keys

Record the Key Number on page 4

EP 08/12/29 (2)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-29 (2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST486

JS 08/12/30 (X2)

Record Key #

C420A . X2

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2)

09/01/05

Job Completion



MF 08-12-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

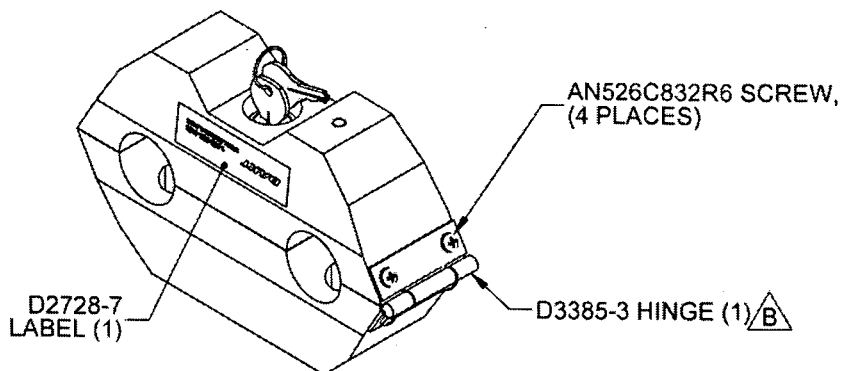
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

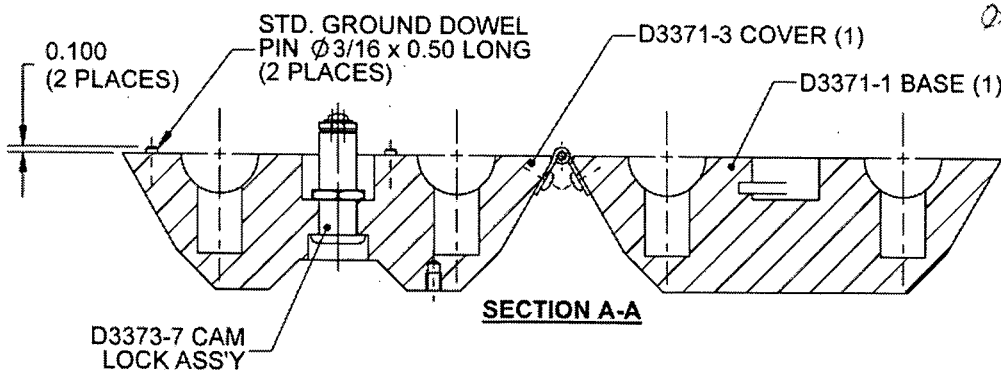


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DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

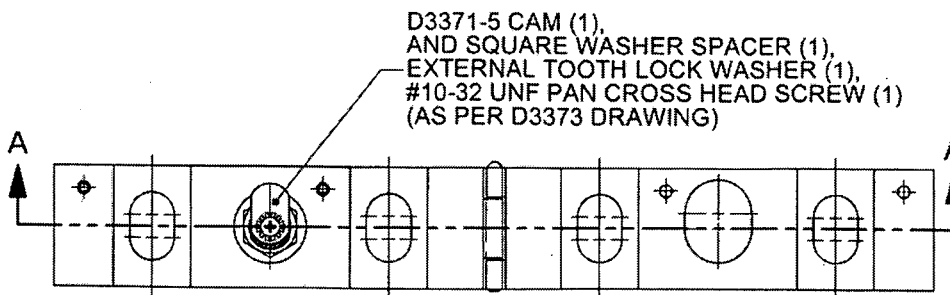


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



SECTION A-A



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

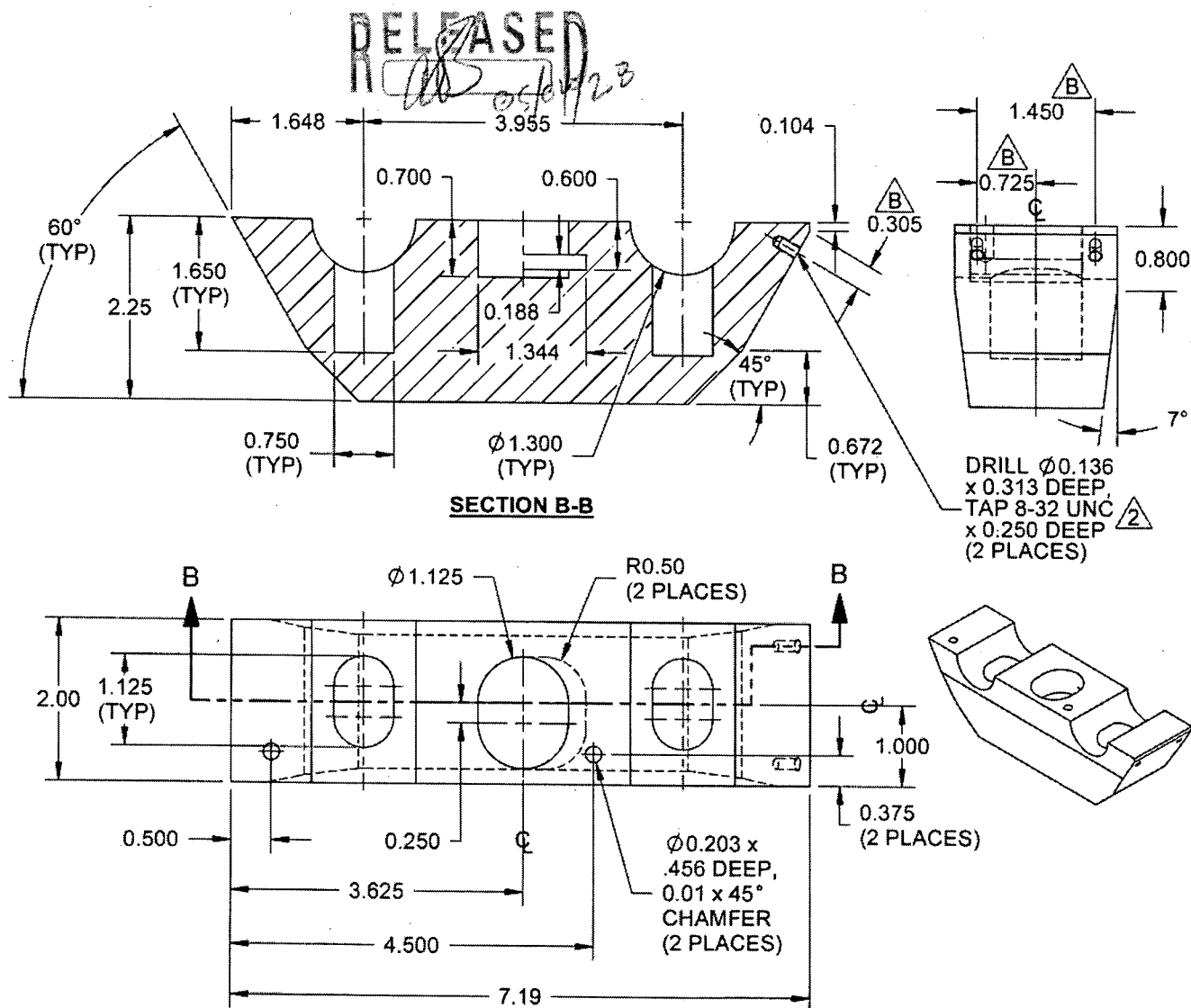
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DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



D3371-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

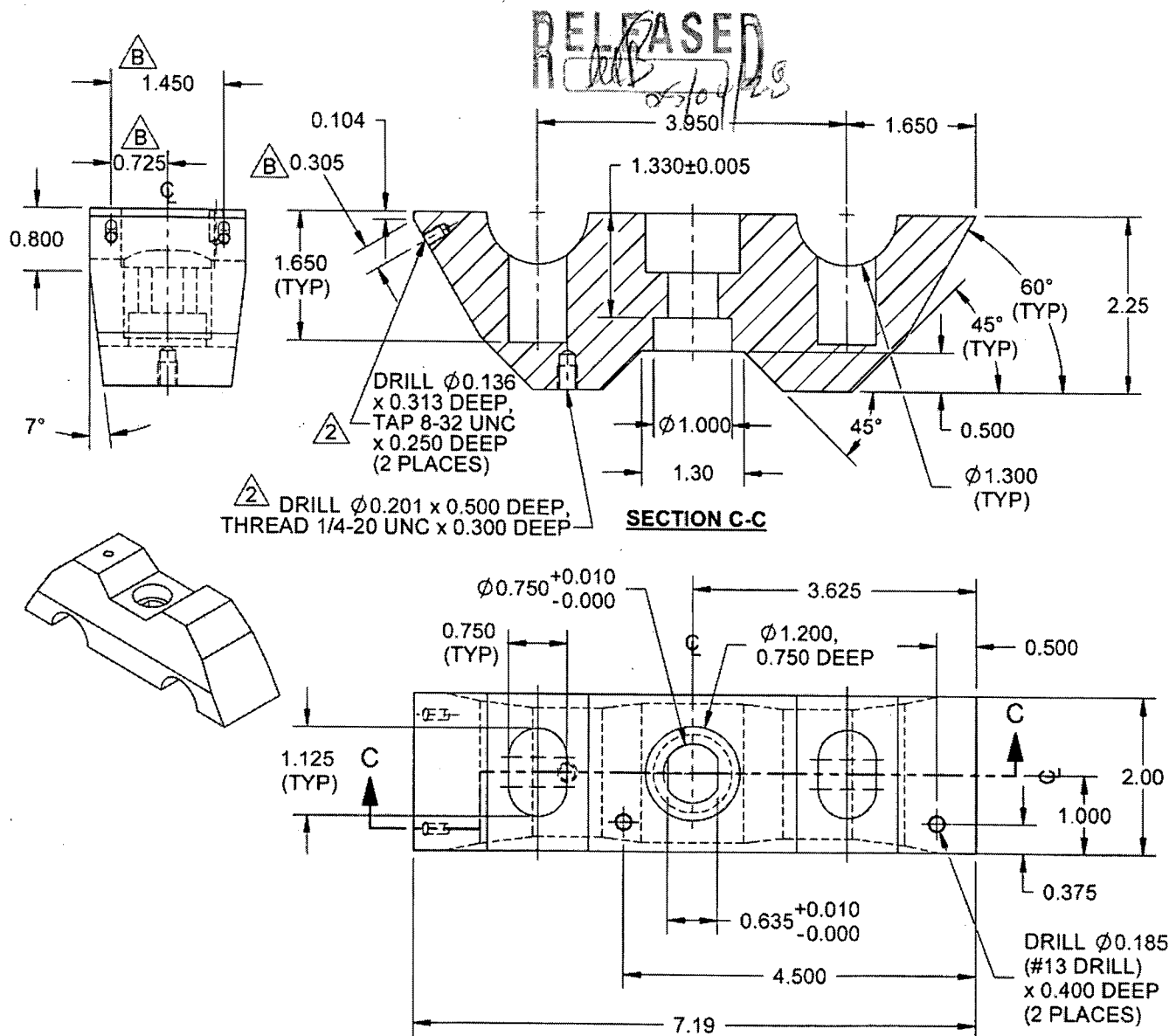
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DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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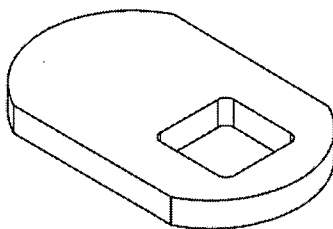
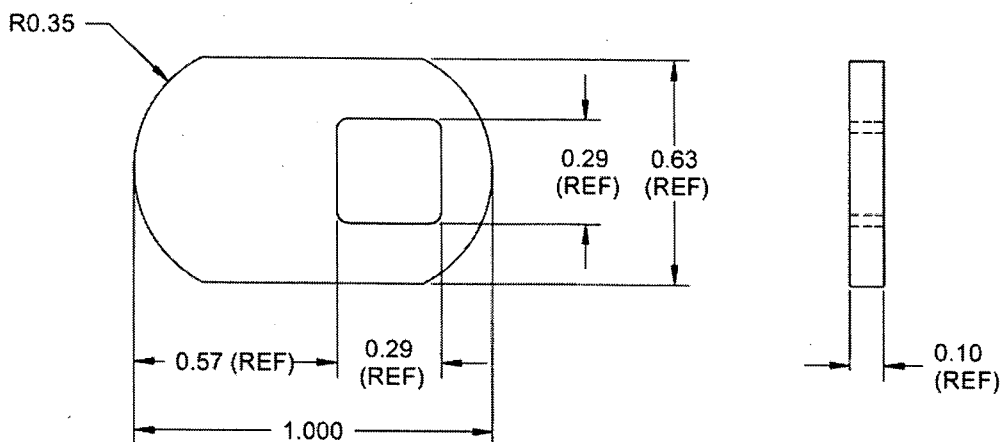
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DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/23

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

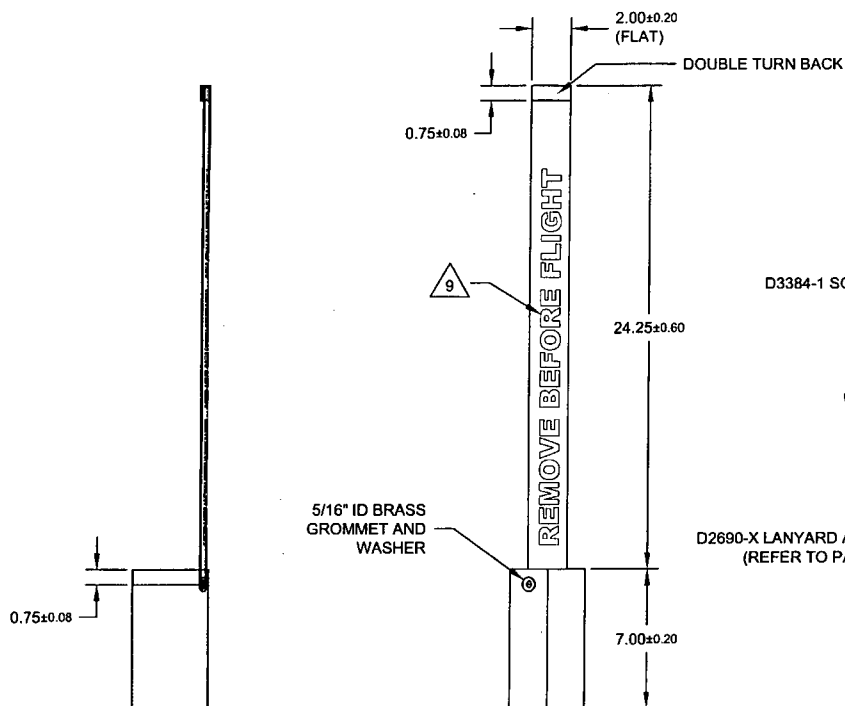
NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

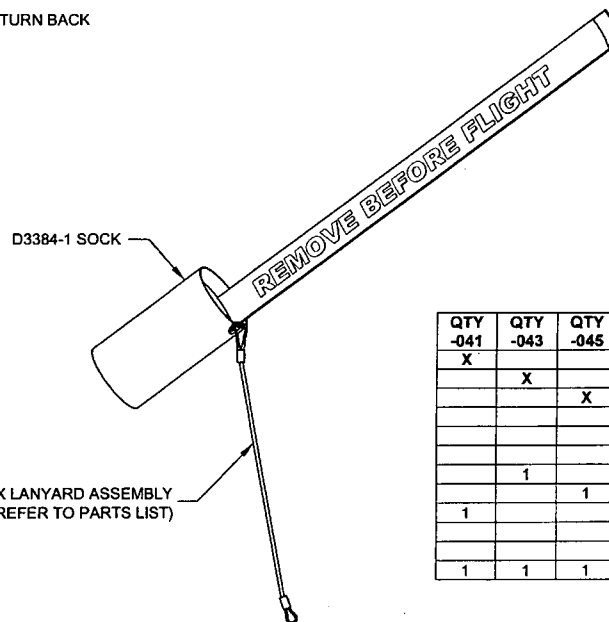
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D3384-1 SOCK



D3384-0XX SOCK ASSEMBLY

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
X					D3384-041	SOCK ASSEMBLY
	X				D3384-043	SOCK ASSEMBLY
		X			D3384-045	SOCK ASSEMBLY
			X		D3384-047	SOCK ASSEMBLY
				X	D3384-049	SOCK ASSEMBLY
	1				D2690-8	LANYARD ASSEMBLY
		1			D2690-20	LANYARD ASSEMBLY
1					D2690-24	LANYARD ASSEMBLY
			1		D2690-28	LANYARD ASSEMBLY
				1	D2690-30	LANYARD ASSEMBLY
1	1	1	1	1	D3384-1	SOCK

RELEASED
07.11.23

D3384-1 NOTES:

- SUPPLIER: TULMAR P/N 8972
- MATERIAL: 420 DENIER NYLON CLOTH, PVC COATED, COLOUR RED
- THREAD: STITCHING IAW D-6193 6 TO 10 STITCHES PER INCH USING V-T-295 RED NYLON THREAD, TY2, CL A, SIZE E
- FINISH: NONE
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: NONE
- WEIGHT: N/A
- STENCIL THE FOLLOWING: "REMOVE BEFORE FLIGHT" ON BOTH SIDES OF STRIP WITH 1" LETTERS USING INK, WHITE, IAW A-A-208

B	CHG TOLERANCES DWG UPDATED ADD MATERIAL & SUPPLIER INFO	DC	07.11.23
A	NEW ISSUE	RF	05.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	IC		
CHECKED	IC		
MFG. APPR.	IC		
APPROVED	MD		
DE APPR.	N/A		
DATE	07.11.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3384	REV. B SHEET 1 OF 1
TITLE SOCK ASSEMBLY	SCALE NTS
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